BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

As rescanning documents *will not* correct images, please do not report the images to the Image Problem Mailbox.

UNITHERM FOOD SYSTEMS INCORPORATED
1108 WEST HARTFORD
PONCA CITY, OKLAHOMA 74601
TELEPHONE: 405-762-0197
405-762-0199

A WORLD OF STAINLESS STEEL PRODUCTS

May 02, 1996

FAXED 05-02-96

Dick Taylor
PLANTATION FOODS
P. O. Box 20788
Waco, TX 76702-0788

Via Fax # 817-799-5229

RE: Quote #299DH

Dear Dick:

I would like to thank you and your colleagues for taking the time to travel to Ponca City.

Enclosed for your approval are quotations and drawings for the four products we discussed: (1 RapidFlow, 2) Liquid Smoke Enrober, 3) Rotisserie, 4) Nitrogen Tunnel.

Process Parameters

Product:	Turkey / Chicken Crowns
Initial Temperature:	40°C
Cook / Brown Temperature:	300°C
Residence Time:	7-1/2 to 10 minutes
Steam Injection:	2 Bar (not required for browning)

Anticipated Throughputs based on following data:

Crown Size / Foot Print:	8" x 12"
Initial Weight:	10 lb.
Finished Weight:	98 - 99 percent
Throughput (Raw):	4800 lb. (10 minute dwell time)

UNITHERM RAPIDFLOW II CONTINUOUS CONVECTION OVEN RF2

U-03700

Belt Height:	40"
Belt Width	40"
Belt Type:	Flat flex wire belt
Overall Length:	20'
Cooking Length:	17'
Drive Motors:	1 off, SEW geared motor. IP 55 (1.3kW)
Belt Speed:	2 minute minimum; 4 hour maximum
Circulation Fans:	6 off, stainless steel impeller (6 x 0.75 kW) Balanced by UNITHERM to provide even heat across entire belt width.
Steam Injection System:	Into cooking chamber. Nominally 80 kgs per hour maximum at 2 bar dry saturated. (Independently controllable.)
Extraction Fan:	2 off, Bifurcated 2000 cfm variable (0.75kW). Stainless steel construction.
Belt Washer (Continuous):	High pressure (25 bar) pump. Adjustable weir plate within washer to regulate water usage / effluent discharge. Pump close-coupled to 15 kW drive motor.
Heating System:	Comprised of 48 x 2 kW finned incalloy elements per zone. Elements designed to maximize efficient heat transfer (192 kW total heating load). Elements controlled via electronic thyristor drive to maximize energy efficiency. To maximize start-up time, full energy usage allows the oven to reach maximum temperature (350^{o}C) within 15 minutes from cold. PID temperature controllers within each zone allow accurate set point control of +/- 1^{o}C.
Fire Protection Systems:	Operated by a solid-state, approved fire detector. Twin systems, steam at nominally 6 bar to flood the lower chamber and cooking area. Mains water into the oven top

canopy. Pressure switches ensure pressure available to allow machine to operate.

General Construction: All AISI 304 stainless steel. Main framework constructed from 40 x 40 RHS. Inner chamber allowed to "Free Float" for expansion purposes. Height adjustable, self-leveling feet fitted. Outer canopies hinged to allow cleaning. During hygiene, all belt support rods are easily removed and refitted.

Fat collection tray in lower cooker chamber with 3"-diameter outfeed pipe to drain / collection system. Baffle plates on circulation fans are removable for hygiene. All pipework has de-mountable fitting to allow hygiene.

Control Panel: Stainless steel IP 65, clear macrolon cover over door furniture and controllers. Visual display of temperature in each zone. Visual display of belt speed (frequency). General control gear telemecanique.

All Up Power Requirements:

Heating System:	192 kW
Circulation Fans:	4.5 kW
Extraction Fans:	3 kW
Belt Washer:	15 kW
Controls, etc.	2 kW
Drive Motors:	2 kW
Total:	218.5 kW

Running Costs

During start-up (15 minutes), 100 percent power is required during normal operation; the thyristor drive modulates the load to nominally 30 percent of the P.L.C.; this equates to 70 kW. Given an industrial cost per kWH of 77 cents, this gives a running cost of nominally $4.90 per hour.

Costs of maintenance are minimal. A weekly check of all components will take one hour, due to the "Maintenance Friendly" design of the machine.

COMMERCIAL QUOTATION

UNITHERM RapidFlow II RF-2 $ 250,000

Installation - 2 engineers, 2 days		$ 3,800
Delivery Charge	Budget	$ 2,400

Commercial Notes

Installation includes the following:

Mechanical erection and leveling
Electrical interconnection using stainless steel and flexible conduit
Functional testing of all systems
Fire suppression system testing

Exclusions

Civil engineering work
Ducting from top of extract fans through roof space
Service connections (mains, incomer, steam, water, drains)

Commissioning

Commissioning will commence upon completion of installation.
Commissioning is charged at $50 per hour for all hours worked, including traveling.
Out-of-pocket expenses and hotels will be charged at cost, or if preferred, settled directly by the client.
Signed timesheets to be submitted for approval; these form the basis of invoices.

Documentation

Machine will be supplied with one full instruction manual including electrical drawings.

Spares

A comprehensive spares listing with recommended stock holding will be supplied after order placement.

UNITHERM ROTISSERIE/ CONTINUOUS ROASTER / STEAMER
Your ref. for Turkey Parts

The Unitherm Captive Tray System (CTS) Rotisserie / Continuous Roaster / Steamer utilizes the advantages of a continuous process, with the throughputs of a batch system.

The system uses a vertical stacking system to maximize throughput, minimize floor space, and reduce energy / steam requirements.

The trays are 40" x 40", and are filled with product to maximize the loading density. An automated infeed system indexes the tray into the system. The trays then rise vertically on stainless steel carriers. At the top of the stack, a motorized pusher traverses the tray onto the de-elevating stack. Outfeed transport chains allow the trays to discharge from the system.

Infeed and discharge closures are pneumatically activated to eliminate steam leakage. Extraction canopies are positioned over the infeed and discharge, connected to the extraction fan spigot on the top of the cabinet.

A variable speed controller allows dwell times from 5 minutes to 5 hours. A digital display on the control panel provides a readout in hours / minutes / seconds for accurate control over process parameters. The display shows actual process temperature and setpoint.

Electrics are 150 kW, thyristor controlled.

Foot Print:	15' long x 60" wide x 11' tall
Tray Capacity:	16 / 32 (See Pitches)
Tray Sizing:	40" x 40"
Residence Time	5 minutes to 5 hours
Carrier Pitch	8" and 4"
Circulation Fans	2 off, 6000 cfm aluminum impellers
Extraction Fan:	1 off, 600 cfm variable
Infeed / Discharge Closures:	Dual action, pneumatically operated
Chain Transport:	2" pitch stainless steel chain
Infeed Discharge Chains:	1" pitch stainless steel chain
Construction:	All grade 304 stainless steel 2"-thick rockwool insulated throughout 1/2"-thick base plate to eliminate distortion Unit mounted on legs to allow under cleaning

Safety-interlocked access door provided
60"-long infeed and discharge conveyors

Control Panel:
Contains all drives and controls
Mitsubishi PLC controls for mechanical handling
Jumo, PID controller for temperature management
LED resident time indicator powered from rotary encoder
Rotary encoder
All control and safety circuits

Supplied with all safety equipment and CE Certification.

This unit is equivalent to a linear oven 106' long (when using the 4" pitch).

COMMERCIAL QUOTATION

Price Ex Works Ponca City, Oklahoma		$ 285,000
Unitherm Captive Trays for use within the system - 40" x 40" x 1-1/2" high (Estimated requirements 60 trays)	Price each	$ 200
Delivery Charge	Budget	$ 3,000

SMOKE / LIQUID APPLICATOR

This would be designed to re-circulate the liquid in a partial dip tank. There would be an automatic self-leveling infeed from a header tank to assure a minimum of by-product. The process would filter out particulate.

Detail drawings would be supplied for approval.

Price Ex Works Ponca City, Oklahoma $ 25,000

Delivery Lead Time - All of the Above

16 - 20 weeks from receipt of confirmed order and deposit. Lead time commences from receipt of deposit and agreement of drawings.

NITROGEN TUNNEL

Product Processing Knowledge

4" x 6" x 48" long logs
4" x 4" x 48" long logs
4" x 6" D-shaped logs
Outer surface to be crusted for slicing.
Product throughput to be 5,000 lbs per hour.
Dwell time for the product is maximum of 5 minutes

Foot Print: See enclosed drawings
Nominal 9' long x 60" wide x 60" tall
Access for cleaning via 4 drop-down doors
The nitrogen is disseminated through a ring main
Construction material is stainless steel, with insulated panels and tunnel
Usable belt width of 48"; height 40"

Full engineering drawings will be supplied for approval. Commissioning trials will be conducted at Ponca City prior to delivery.

Price Ex Works Ponca City, Oklahoma $ 138,500

Delivery would be 8 weeks from receipt of deposit and purchase order

Payment Terms on All Items

30% Deposit with purchase order
60% Prior to shipment, upon inspection at UNITHERM
10% Retention due 30 days after completion of installation

Terms and Conditions of Sale

This contract is subject to UNITHERM'S standard terms and conditions of sale printed on the reverse of this quotation's cover sheet.

I trust this quotation will meet with your approval; I look forward to speaking with you soon.

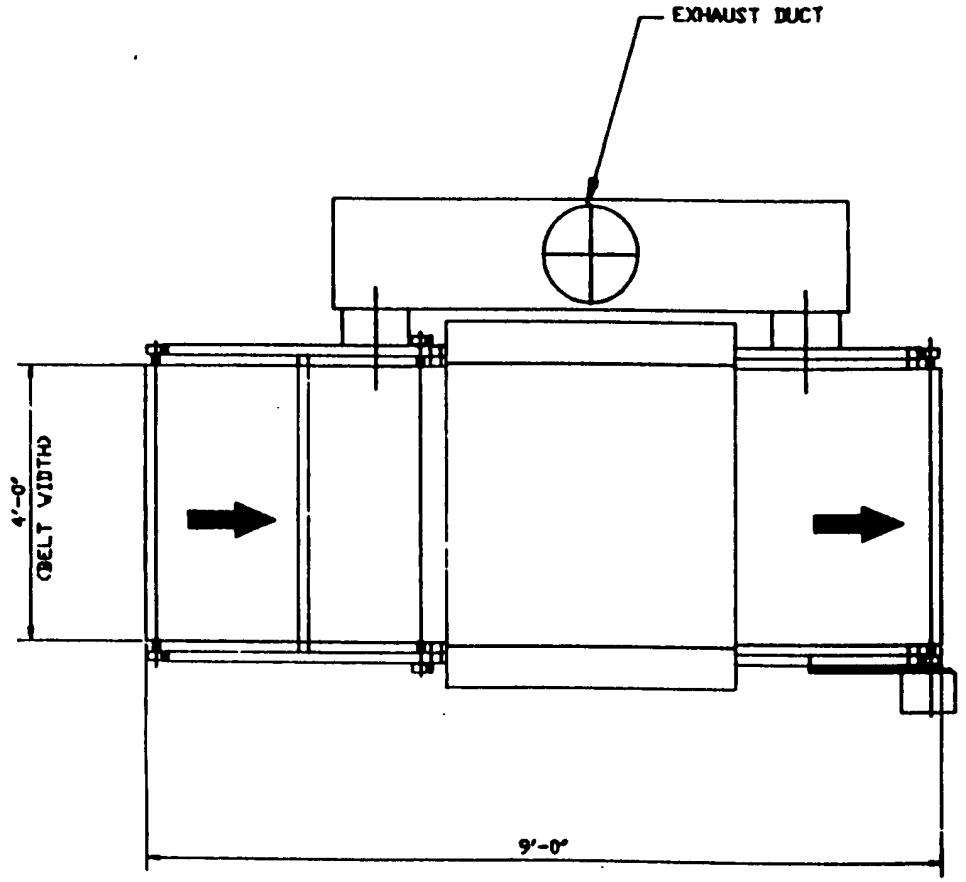
Regards,

David Howard
President

DO NOT SCALE IF IN DOUBT ASK.

PTO-003988

U-03707



ISSUED	REVISIONS	

UNITHERM
FOOD SYSTEMS
DESIGN AND MANUFACTURE

1100 WEST HASTINGS
PORT COQ, BRITISH COLUMBIA
TEL. 463 703 0407 FAX. 463 703 0109

TITLE
48" WIDE NITROGEN TUNNEL
(FLOOR PLAN)

DRAWN	CHECKED	APPROVED	DATE
CF			5-2-00

SCALE NTS

DRAWING No. A_0188

Systems can be configured to steam/roast/smoke/chill

Multi-zone configuration allows individual cooking processes to be developed

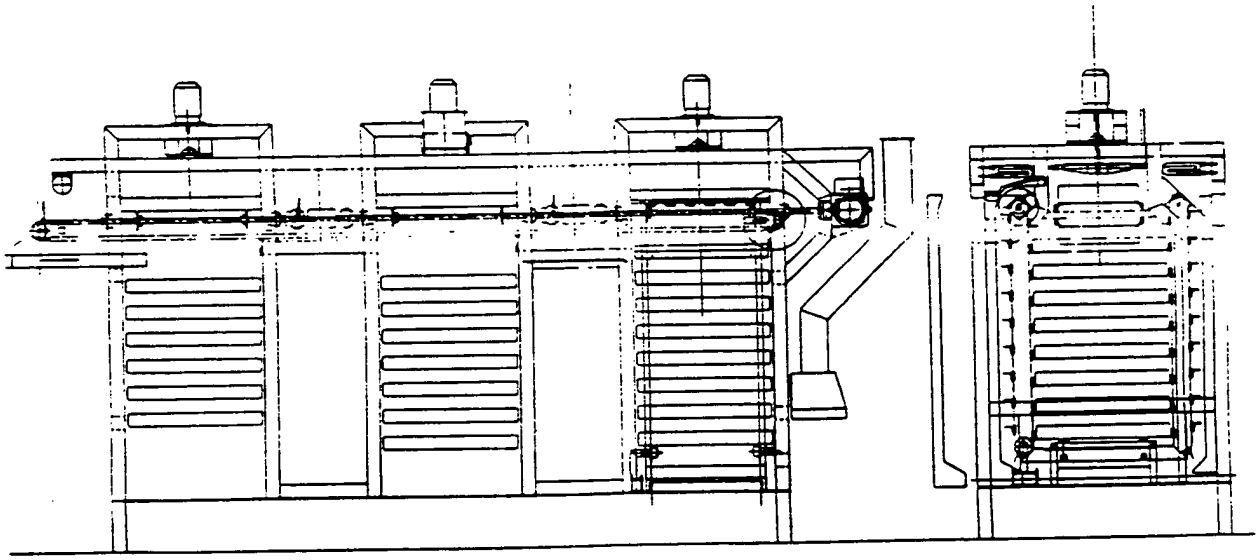
Higher yields than associated with traditional batch systems

Throughputs: 150 - 2500 kg's/hour

Optional CiP system provides thorough cleaning of the machine with minimal production downtime

Automated loading and unloading systems available

Eliminates the need for trollies within the process area



UNITHERM

BAILEY ROAD, TRAFFORD PARK
MANCHESTER, M17 1SA
TEL: 0161 848 8954 FAX: 0161 848 8955

U-03708

UNITHERM FOOD SYSTEMS
1108 WEST HARTFORD
PONCA CITY
OKLAHOMA 74601

AGENTS STAMP

UNITHERM STAINLESS STEEL
34 REGAL ROAD
WISBECH
CAMBRIDGESHIRE, PE13 2RQ
TEL · 01945 475767

Continuous captive tray technology keeps trays within the system providing the high throughput benefits of batch processing within a continuous, labour free system

Throughputs: 200 - 5000 Kg's/hour

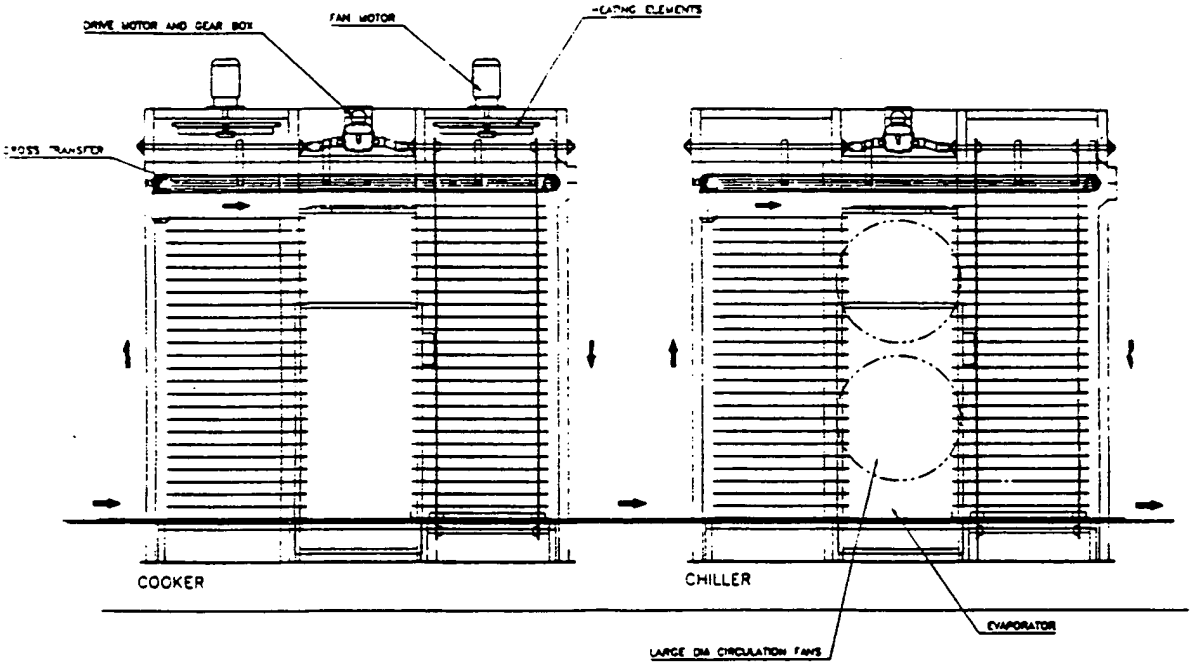
Steaming or combination steaming/dry heat technology

Efficient mechanical chilling system provides minimal chilling cycle times

Automated loading/unloading systems available

In-line traywashers provide continuous loop operation

Full turnkey installation packages



UNITHERM
BAILEY ROAD, TRAFFORD PARK
MANCHESTER, M17 1SA
TEL: 0161 848 8954 FAX: 0161 848 8955

U-03709

UNITHERM FOOD SYSTEMS **1108 WEST HARTFORD** **PONCA CITY** OKLAHOMA 74601	AGENTS STAMP	**UNITHERM STAINLESS STEEL** **34 REGAL ROAD** **WISBECH** CAMBRIDGESHIRE PE13 2PQ

PTO-003990